

PATENT COOPERATION TREATY

**CORRECTED
VERSION****NOTIFICATION OF THE RECORDING
OF A CHANGE**(PCT Rule 92bis.1 and
Administrative Instructions, Section 422)

From the INTERNATIONAL BUREAU

To:

VANTICO AG
Patents/Scientific Information
Klybeckstrasse 200
CH-4057 Basel
SUISSEDate of mailing (day/month/year)
14 December 2000 (14.12.00)Applicant's or agent's file reference
AT/K-21957/A/MA 2175**IMPORTANT NOTIFICATION**International application No.
PCT/EP99/10040International filing date (day/month/year)
17 December 1999 (17.12.99)

1. The following indications appeared on record concerning:

☒ the applicant ☐ the inventor ☐ the agent ☐ the common representative

Name and Address

CIBA SPECIALTY CHEMICALS HOLDING
INC.
Klybeckstrasse 141
CH-4057 Basel
SwitzerlandState of Nationality
CHState of Residence
CH

Telephone No.

Facsimile No.

Teleprinter No.

2. The International Bureau hereby notifies the applicant that the following change has been recorded concerning:

☒ the person ☐ the name ☐ the address ☐ the nationality ☐ the residence

Name and Address

VANTICO AG
Klybeckstrasse 200
CH-4057 Basel
SwitzerlandState of Nationality
CHState of Residence
CH

Telephone No.

Facsimile No.

Teleprinter No.

3. Further observations, if necessary:

**Please also note the change of common representative on the addressee box of this
notification.**

4. A copy of this notification has been sent to:

☒ the receiving Office ☐ the designated Offices concerned
☐ the International Searching Authority ☒ the elected Offices concerned
☒ the International Preliminary Examining Authority ☐ other:The International Bureau of WIPO
34, chemin des Colombettes
1211 Geneva 20, Switzerland

Authorized officer

C. Cupello

Facsimile No.: (41-22) 740.14.35

Telephone No.: (41-22) 338.83.38

P^ATENT COOPERATION TREATY

PCT

NOTIFICATION OF THE RECORDING
OF A CHANGE(PCT Rule 92bis.1 and
Administrative Instructions, Section 422)

From the INTERNATIONAL BUREAU

To:

VANTICO AG
Patents/Scientific Information
Klybeckstrasse 200
CH-4002 Basel
SUISSEDate of mailing (day/month/year)
27 July 2000 (27.07.00)Applicant's or agent's file reference
AT/K-21957/A/MA 2175

IMPORTANT NOTIFICATION

International application No.
PCT/EP99/10040International filing date (day/month/year)
17 December 1999 (17.12.99)

1. The following indications appeared on record concerning:

☒ the applicant ☐ the inventor ☐ the agent ☐ the common representative

Name and Address

CIBA SPECIALTY CHEMICALS HOLDING
INC.
Klybeckstrasse 141
CH-4057 Basel
Switzerland

State of Nationality

CH

State of Residence

CH

Telephone No.

Facsimile No.

Teleprinter No.

2. The International Bureau hereby notifies the applicant that the following change has been recorded concerning:

☒ the person ☐ the name ☐ the address ☐ the nationality ☐ the residence

Name and Address

VANTICO AG
Klybeckstrasse 200
CH-4057 Basel
Switzerland

State of Nationality

CH

State of Residence

CH

Telephone No.

Facsimile No.

Teleprinter No.

3. Further observations, if necessary:

**Please also note the change of common representative on the addressee box of this
notification**

4. A copy of this notification has been sent to:

☒ the receiving Office ☐ the designated Offices concerned
☐ the International Searching Authority ☒ the elected Offices concerned
☒ the International Preliminary Examining Authority ☐ other:The International Bureau of WIPO
34, chemin des Colombettes
1211 Geneva 20, Switzerland

Authorized officer

C. Cupello

Facsimile No.: (41-22) 740 14 35

Telephone No.: (41-22) 338 83 38

PATENT COOPERATION TREATY

PCT

NOTIFICATION OF ELECTION

(PCT Rule 61.2)

From the INTERNATIONAL BUREAU

To:

Assistant Commissioner for Patents
United States Patent and Trademark
Office
Box PCT
Washington, D.C. 20231
ETATS-UNIS D'AMERIQUE

in its capacity as elected Office

Date of mailing: 22 June 2000 (22.06.00)	
International application No.: PCT/EP99/10040	Applicant's or agent's file reference: AT/K-21957/A/MA 2175
International filing date: 17 December 1999 (17.12.99)	Priority date: 17 December 1998 (17.12.98)
Applicant: ARNOUX, Didier et al	

1. The designated Office is hereby notified of its election made:

☒ in the demand filed with the International preliminary Examining Authority on:
27 April 2000 (27.04.00)

☐ in a notice effecting later election filed with the International Bureau on:

2. The election ☒ was
☐ was not

made before the expiration of 19 months from the priority date or, where Rule 32 applies, within the time limit under Rule 32.2(b).

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland Facsimile No.: (41-22) 740 14 35	Authorized officer: J. Zahra Telephone No.: (41-22) 338 83 38
---	---

M

From the INTERNATIONAL BUREAU

PCT

**NOTICE INFORMING THE APPLICANT OF THE
COMMUNICATION OF THE INTERNATIONAL
APPLICATION TO THE DESIGNATED OFFICES**

(PCT Rule 47.1(c), first sentence)

To:
CIBA SPECIALTY CHEMICALS HOLDING
INC.
Patent Department
Klybeckstrasse 141
CH-4002 Basel
SUISSE

Date of mailing (day/month/year) 22 June 2000 (22.06.00)		IMPORTANT NOTICE	
Applicant's or agent's file reference AT/K-21957/A/MA 2175			
International application No. PCT/EP99/10040	International filing date (day/month/year) 17 December 1999 (17.12.99)	Priority date (day/month/year) 17 December 1998 (17.12.98)	
Applicant CIBA SPECIALTY CHEMICALS HOLDING INC. et al			

1. Notice is hereby given that the International Bureau has communicated, as provided in Article 20, the international application to the following designated Offices on the date indicated above as the date of mailing of this Notice:
AU,JP,KR,US

In accordance with Rule 47.1(c), third sentence, those Offices will accept the present Notice as conclusive evidence that the communication of the international application has duly taken place on the date of mailing indicated above and no copy of the international application is required to be furnished by the applicant to the designated Office(s).

2. The following designated Offices have waived the requirement for such a communication at this time:
CA,EP,ZA

The communication will be made to those Offices only upon their request. Furthermore, those Offices do not require the applicant to furnish a copy of the international application (Rule 49.1(a-bis)).

3. Enclosed with this Notice is a copy of the international application as published by the International Bureau on
 22 June 2000 (22.06.00) under No. WO 00/35983

REMINDER REGARDING CHAPTER II (Article 31(2)(a) and Rule 54.2)

If the applicant wishes to postpone entry into the national phase until 30 months (or later in some Offices) from the priority date, a **demand for international preliminary examination** must be filed with the competent International Preliminary Examining Authority before the expiration of 19 months from the priority date.

It is the applicant's sole responsibility to monitor the 19-month time limit.

Note that only an applicant who is a national or resident of a PCT Contracting State which is bound by Chapter II has the right to file a demand for international preliminary examination.

REMINDER REGARDING ENTRY INTO THE NATIONAL PHASE (Article 22 or 39(1))

If the applicant wishes to proceed with the international application in the **national phase**, he must, within 20 months or 30 months, or later in some Offices, perform the acts referred to therein before each designated or elected Office.

For further important information on the time limits and acts to be performed for entering the national phase, see the Annex to Form PCT/IB/301 (Notification of Receipt of Record Copy) and Volume II of the PCT Applicant's Guide.

<p style="text-align: center;">The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland</p> <p>Facsimile No. (41-22) 740.14.35</p>	<p>Authorized officer <div style="text-align: center;">J. Zahra</div> Telephone No. (41-22) 338.83.38</p>
--	---

INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(PCT Article 36 and Rule 70)

Applicant's or agent's file reference AT/K-21957/A/MA 2175	FOR FURTHER ACTION See Notification of Transmittal of International Preliminary Examination Report (Form PCT/IPEA/416)	
International application No. PCT/EP99/10040	International filing date (day/month/year) 17/12/1999	Priority date (day/month/year) 17/12/1998
International Patent Classification (IPC) or national classification and IPC C08G18/48		
Applicant VANTICO AG		

1. This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.



2. This REPORT consists of a total of 5 sheets, including this cover sheet.

- ☐ This report is also accompanied by ANNEXES, i.e. sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).

These annexes consist of a total of sheets.

3. This report contains indications relating to the following items:

- I ☒ Basis of the report
- II ☐ Priority
- III ☐ Non-establishment of opinion with regard to novelty, inventive step and industrial applicability
- IV ☐ Lack of unity of invention
- V ☒ Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement
- VI ☐ Certain documents cited
- VII ☐ Certain defects in the international application
- VIII ☐ Certain observations on the international application

Date of submission of the demand 27/04/2000	Date of completion of this report 06.02.2001
Name and mailing address of the international preliminary examining authority.  European Patent Office D-80298 Munich Tel +49 89 2399 - 0 Tx: 523656 epmu d Fax: +49 89 2399 - 4465	Authorized officer Kolitz, R Telephone No. +49 89 2399 8481 

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/EP99/10040

I. Basis of the report

1. This report has been drawn on the basis of *(substitute sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to the report since they do not contain amendments (Rules 70.16 and 70.17).):*

Description, pages:

1-16 as originally filed

Claims, No.:

1-19 as originally filed

2. With regard to the **language**, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.

These elements were available or furnished to this Authority in the following language: , which is:

- ☐ the language of a translation furnished for the purposes of the international search (under Rule 23.1(b)).
☐ the language of publication of the international application (under Rule 48.3(b)).
☐ the language of a translation furnished for the purposes of international preliminary examination (under Rule 55.2 and/or 55.3).

3. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international preliminary examination was carried out on the basis of the sequence listing:

- ☐ contained in the international application in written form.
☐ filed together with the international application in computer readable form.
☐ furnished subsequently to this Authority in written form.
☐ furnished subsequently to this Authority in computer readable form.
☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

4. The amendments have resulted in the cancellation of:

- ☐ the description, pages:
☐ the claims, Nos.:
☐ the drawings, sheets:

5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed (Rule 70.2(c)):

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT**

International application No. PCT/EP99/10040

(Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report.)

6. Additional observations, if necessary:

V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement

1. Statement

Novelty (N)	Yes:	Claims	5,8,9,14,17,18
	No:	Claims	1-4,6-7,10-13,15-16,19
Inventive step (IS)	Yes:	Claims	
	No:	Claims	5,8,9,14,17,18
Industrial applicability (IA)	Yes:	Claims	1-19
	No:	Claims	

2. Citations and explanations
see separate sheet

**INTERNATIONAL PRELIMINARY
EXAMINATION REPORT - SEPARATE SHEET**

International application No. PCT/EP99/10040

Re item V:

Reasoned statement with regard to novelty and inventive step and industrial applicability. Article 33 (1) to (4) PCT:

D1: EP-A-0 376 674 (MITSUI TOATSU CHEMICALS) 4 July 1990 (1990-07-04)

1. Lack of novelty of the subject-matter of claims 1-4, 6-7, 10-13, 15-16 and 19 in the sense of Article 33 (2) PCT:

1.1. D1, see the whole document, in particular examples 1-3 and table 1, discloses a polyurethane /urea -forming composition for floor covering comprising a reaction mixture of (a) an isocyanate component that contains or has been reacted with polytetramethylene glycol (PTMG), (b) an aromatic amine curative (diethyl toluene diamine (DETDA)) and (c) a phthalate ester having a vapour pressure of less than 100 mPa at 25°C (dioctylphthalate (DOP)) i.e. the same ingredients as in present claims 10, 12 (PTMG) and 13 (DETDA).

The subject-matter of claims 10, 12 und 13 is therefore not novel.

As MDI is used in the examples of D1 as the isocyanate component no TDI is present and component (a) is a low free toluene diisocyanate prepolymer blend having a free TDI content of below 0.4%.

The subject-matter of claim 11 is not novel.

In the examples of D1 the polyester polyol (EA-2000) and/or the polyether polyol PTMEG-1000, PTMG-650 to be combined with the other components (a)-(c) have a M_n of ≥ 250 as disclosed in present claim 15. The softener is DOP thus falling under formula (IB) in present claim 16.

The subject-matter of claims 15 and 16 is not novel.

1.2. The subject-matter of claims 1-4, 6-7 and 19 is also not novel vis-à-vis D1, examples 2 and 3. According to the general description of examples 1-3 on page 6, lines 13-20 a specific spray machine is used wherein the temperature is set at 50°C and 60°C for solutions A and B, respectively. Spraying is carried out on a polypropylene sheet as a mold to obtain a sheet of a thickness of 2mm. "In moulding" temperatures on the sheet under the spray conditions are reported in table 1. Table 1 on page 9 shows e.g. for example 3 an "in moulding"

temperature of 23 °C. Thus the polyurethane /urea -forming composition disclosed in D1, table 1 is clearly castable and curable at temperatures between 15 and 25 °C and therefore this feature cannot establish the novelty in claims 1-4 and 6-7 and 19.

Thus the subject-matter of claims 1-4 and 6-7 is in fact the same as that of claims 10-13 and 15-16 and the reasons for lack of novelty of these claims set out under point 1.1. apply also to the subject-matter of claims 1-4, 6-7.

Therefore the subject-matter of claims 1-4, 6-7 and 19 is not novel.

- 2.1. The subject-matter of claims 5 and 14 and 8,9,17 and 18 is novel since the aromatic amine "dimethylthiotoluene diamine" and the two phosphate plasticisers mentioned therein are not disclosed in the available prior art.
- 2.2. The subject-matter of claims 5 and 14 and 8, 9, 17 and 18 appears to be obvious in the sense of Article 33 (3) PCT, because the application of a specific phosphate softener as disclosed in claims 8,9,17,18 or the specific aromatic amine as disclosed in claims 5,14 appear at first glance to be routine variations which come within the scope of the customary practice followed by persons skilled in the art.
3. The subject-matter of claims 1-19 appears to be industrially applicable in the sense of Art. 33 (4) PCT .

PATENT COOPERATION TREATY

PCT

INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

Applicant's or agent's file reference AT/K-21957/A/MA 2175	FOR FURTHER ACTION <small>see Notification of Transmittal of International Search Report (Form PCT/ISA/220) as well as, where applicable, item 5 below.</small>	
International application No. PCT/EP 99/10040	International filing date (day/month/year) 17/12/1999	(Earliest) Priority Date (day/month/year) 17/12/1998
Applicant CIBA SPECIALTY CHEMICALS HOLDING INC. et al.		

This International Search Report has been prepared by this International Searching Authority and is transmitted to the applicant according to Article 18. A copy is being transmitted to the International Bureau.

This International Search Report consists of a total of 3 sheets.

☒ It is also accompanied by a copy of each prior art document cited in this report.

1. Basis of the report

a. With regard to the language, the International search was carried out on the basis of the International application in the language in which it was filed, unless otherwise indicated under this item.

☐ the International search was carried out on the basis of a translation of the International application furnished to this Authority (Rule 23.1(b)).

b. With regard to any nucleotide and/or amino acid sequence disclosed in the International application, the International search was carried out on the basis of the sequence listing:

☐ contained in the International application in written form.

☐ filed together with the International application in computer readable form.

☐ furnished subsequently to this Authority in written form.

☐ furnished subsequently to this Authority in computer readable form.

☐ the statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the International application as filed has been furnished.

☐ the statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished.

2. ☐ Certain claims were found unsearchable (See Box I).

3. ☐ Unity of invention is lacking (see Box II).

4. With regard to the title,

☒ the text is approved as submitted by the applicant.

☐ the text has been established by this Authority to read as follows:

5. With regard to the abstract,

☒ the text is approved as submitted by the applicant.

☐ the text has been established, according to Rule 38.2(b), by this Authority as it appears in Box III. The applicant may, within one month from the date of mailing of this International search report, submit comments to this Authority.

6. The figure of the drawings to be published with the abstract is Figure No.

☐ as suggested by the applicant.

☐ because the applicant failed to suggest a figure.

☐ because this figure better characterizes the invention.

☒ None of the figures.

INTERNATIONAL SEARCH REPORT

International Application No.

P 99/10040

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C08G18/48 C08G18/10 C08K5/00 C08K5/12 C08K5/51

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08G C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DATABASE WPI Section Ch, Week 199408 Derwent Publications Ltd., London, GB; Class A25, AN 1994-062111 XP002132421 & JP 06 016767 A (BANDO CHEM IND LTD), 25 January 1994 (1994-01-25) abstract ---	1, 3, 4, 7, 10, 12, 13, 16
X	US 3 980 606 A (WERNER BYRON H) 14 September 1976 (1976-09-14) column 1, line 23 -column 2, line 9 examples III, IV ---	1, 3, 7, 10, 12, 16
P, X	FR 2 764 893 A (GANGA ROLAND ALEXANDRE) 24 December 1998 (1998-12-24) example 5 ---	1, 3-5, 10, 12-14

-/--



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

9 March 2000

Date of mailing of the international search report

23/03/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Neugebauer, U

INTERNATIONAL SEARCH REPORT

International Application No

PCT/JP 99/10040

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 376 674 A (MITSUI TOATSU CHEMICALS) 4 July 1990 (1990-07-04) page 3, line 20 - line 28 page 4, line 22 -page 5, line 27 example 1; table 1 ---	1,3,4,7, 10,12, 13,16
A	US 5 688 892 A (ISHII AKIRA ET AL) 18 November 1997 (1997-11-18) cited in the application example 1 -----	1,4,7,19

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/JP 99/10040

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
JP 6016767	A	25-01-1994	JP 2051847 C JP 7072223 B	10-05-1996 02-08-1995
US 3980606	A	14-09-1976	NONE	
FR 2764893	A	24-12-1998	AU 8024698 A WO 9858979 A	04-01-1999 30-12-1998
EP 0376674	A	04-07-1990	CA 2006725 A CN 1048225 A, B DE 68921866 D DE 68921866 T JP 2258877 A KR 9303016 B US 5059671 A	28-06-1990 02-01-1991 27-04-1995 27-07-1995 19-10-1990 16-04-1993 22-10-1991
US 5688892	A	18-11-1997	JP 8143816 A CN 1127512 A WO 9529198 A	04-06-1996 24-07-1996 02-11-1995



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁷: C08G 18/48, 18/10, C08K 5/00, 5/12, 5/51	A1	(11) International Publication Number: WO 00/35983 (43) International Publication Date: 22 June 2000 (22.06.00)
(21) International Application Number: PCT/EP99/10040 (22) International Filing Date: 17 December 1999 (17.12.99) (30) Priority Data: 60/112,656 17 December 1998 (17.12.98) US (71) Applicant (for all designated States except US): CIBA SPECIALTY CHEMICALS HOLDING INC. [CH/CH]; Klybeckstrasse 141, CH-4057 Basel (CH). (72) Inventors; and (75) Inventors/Applicants (for US only): ARNOUX, Didier [FR/FR]; Hameau du Cazal, F-11230 Chalabre (FR). JONES, Crispin, Frank, Maxwell [GB/GB]; 50 Finchams Close, Linton, Cambridge CB1 6NE (GB). ROSENBERG, Ronald, Owen [US/US]; 781 Quarter Mile Road, Orange, CT 06477 (US). (74) Common Representative: CIBA SPECIALTY CHEMICALS HOLDING INC.; Patent Department, Klybeckstrasse 141, CH-4002 Basel (CH).		(81) Designated States: AU, CA, JP, KR, US, ZA, European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>
(54) Title: THERMOSETTING POLY URETHANE/UREA-FORMING COMPOSITIONS (57) Abstract The present invention relates to poly urethane/urea-forming casting composition that can be cast and cured at temperatures between 15 and 35 °C using a reaction mixture of (a) an isocyanate component or an isocyanate functional prepolymer having at least two isocyanate groups per molecule that contains or has been reacted with polytetramethylene glycol; (b) an aromatic amine curative; and (c) a phosphate ester or phthalate ester having a vapor pressure of less than 100 mPa at 25 °C. The present invention further relates to a cast polyurethane and a process for curing a poly urethane/urea-forming composition.		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon			PL	Poland		
CN	China	KR	Republic of Korea	PT	Portugal		
CU	Cuba	KZ	Kazakhstan	RO	Romania		
CZ	Czech Republic	LC	Saint Lucia	RU	Russian Federation		
DE	Germany	LI	Liechtenstein	SD	Sudan		
DK	Denmark	LK	Sri Lanka	SE	Sweden		
EE	Estonia	LR	Liberia	SG	Singapore		

THERMOSETTING POLY URETHANE/UREA-FORMING COMPOSITIONS

This invention relates to casting polyurethane and/or poly urethane/urea-forming products capable of room temperature curing. More particularly, the invention is drawn to liquid compositions containing isocyanate-functional prepolymers, an aromatic amine curative therefore and a non-volatile phosphate or phthalate plasticizer. The selected poly urethane/urea-forming compositions produce, after room-temperature cure, non-sweating, non-distorting castings or boards with superior elasticity, toughness, tear strength and abrasion resistance.

BACKGROUND OF THE INVENTION

Aromatic polyisocyanates are well known and are widely used in the preparation of polyurethane and poly urethane/urea elastomers. These aromatic diisocyanates generally include compositions such as 2,4-toluene diisocyanate, 2,6-toluene diisocyanate, 4,4'-methylene bis (phenylisocyanate) and the like. In the preparation of polyurethane and polyurethane/urea elastomers, the aromatic diisocyanates are reacted with a long chain (high molecular weight) polyol to produce a prepolymer containing free isocyanate groups which then may be chain extended with a short chain (low molecular weight) polyol or aromatic diamine to form a polyurethane or polyurethane/urea elastomer. Long chain, high molecular weight polyols, e.g. those having a molecular weight of above 250, are generally utilized to form the prepolymer and the chain extender is generally a short chain polyol, e.g., C₂-C₁₀ polyol, or an aromatic diamine. The long chain, high molecular weight polyol provides flexibility and elastomeric properties to the resin, while the short chain polyol or aromatic diamine provides chain extension or cross-links and adds toughness and rigidity to the resulting elastomeric polymer.

A major problem with mononuclear aromatic diisocyanates, such as, toluene diisocyanate, relates to the perceived health risks and their volatility. It is known that residual toluene diisocyanate (free toluene diisocyanate) in a prepolymer mixture can be reduced by lowering the isocyanate/hydroxyl ratio of the prepolymer mixture. This modification, however, has a detrimental effect on processing when the prepolymer is chain extended (or cured), namely, the hardness build up rate decreases very significantly, which leads to an

extended demolding time. The prepolymer viscosity also builds up to levels which prevent processability at ambient temperatures.

Alternatively, it is also known that residual toluene diisocyanate may be physically removed from a prepolymer by vacuum distillation or other methods.

It is also known that by incorporating 2,4 toluene diisocyanate dimer into a prepolymer mix, a low NCO/OH ratio can be used to obtain the desired low residual free toluene diisocyanate content while maintaining the desired hardness build up rate. Such a composition is described in U.S. Pat. No. 5,077,371, which is incorporated herein by reference. The prepolymer's viscosity is measured at 100°C and cured at temperatures in excess of 100°C using 4,4'-methylene-bis(3-chloro)aniline. No phosphate ester plasticizers or room temperature curing are described or contemplated by the teachings in the '371 Patent. There is a need for a poly urethane/urea forming composition having a low free toluene diisocyanate content that is capable of being cast and cured at room temperatures.

Plasticizers are commonly used for polyurethane foaming compositions to modify the foam properties or ease processing as described in U.S. Pat. No. 5,817,860. Examples of plasticizers set forth therein are dioctyl phthalate, diisooctyl phthalate, dimethyl phthalate, dibutyl phthalate, tributyl phosphate, triphenyl phosphate, cresyl diphenyl phosphate, halogenated biphenyls and aromatic oils.

U.S. Pat. No. 5,688,892 describes a waterproofing formulation based upon a cold setting polyurethane formulation using a selected aromatic diamine curative and plasticizers and a toluene diisocyanate reacted with a polyoxypropylene or polyoxyethylene polyol. The plasticizer used therein is dioctyl phthalate.

Published European patent application 829,497 describes a polyurethane casting composition based on an isocyanate or isocyanate-function prepolymer, selected aromatic amine curative with a relatively low polarity and hydrocarbon oils as a plasticizer.

Many conventional plasticizers, however, are either too volatile, which leads to dimensional instability, or become physically incompatible after cure, or have insufficient viscosity reducing effect. The present invention overcomes these obstacles to produce a desired

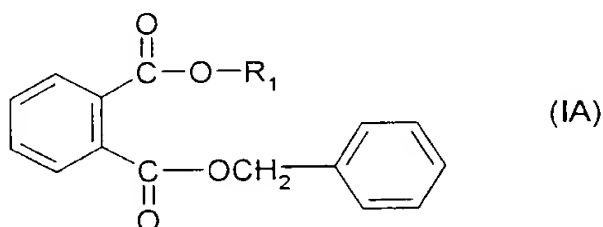
room temperature curable poly urethane/urea-forming product having a low free toluene diisocyanate content.

SUMMARY OF THE INVENTION

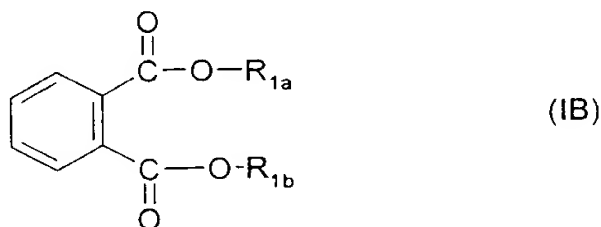
The present invention is, in one embodiment, drawn to a poly urethane/urea-forming casting composition that can be cast and cured at temperatures between 15 and 35°C using a reaction mixture of (a) an isocyanate component or an isocyanate functional prepolymer having at least two isocyanate groups per molecule that contains or has been reacted with polytetramethylene glycol, (b) an aromatic amine curative, and (c) a phosphate ester or phthalate ester having a vapor pressure of less than 100 mPa at 25°C. Component (a) is preferably a low free toluene diisocyanate prepolymer blend. Component (a) more preferably is a prepolymer blend that is a reaction mixture of an organic diisocyanate and polytetramethylene glycol. The casting composition can further include a polyether- and/or polyester polyol having a number average molecular weight of at least 250.

The aromatic amine curative is preferably selected from the group consisting of diethyl toluene diamine, tertiary butyl toluene diamine, dimethylthiotoluene diamine, , and 1,2-bis(2-aminophenylthio)ethane.

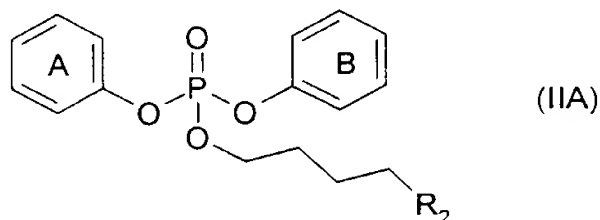
The phosphate ester or phthalate ester is preferably represented by formulae (IA), (IB), (IIA), (IIB) or (III):



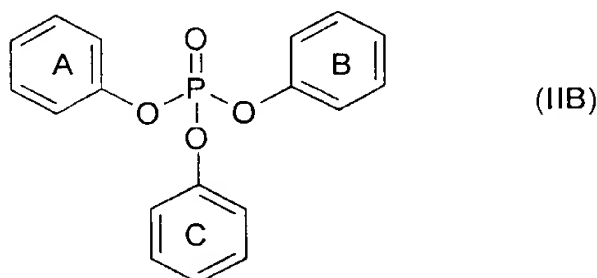
wherein R_1 is unsubstituted or alkyl-substituted C_3 - C_{12} alkyl,



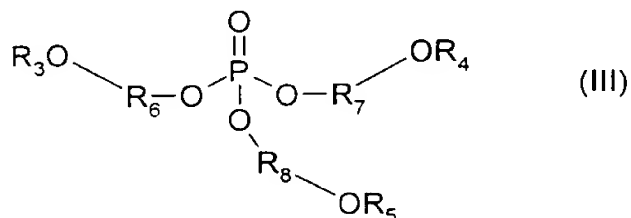
wherein R_{1a} and R_{1b} , independently of one another are unsubstituted or alkyl-substituted C_5 - C_{12} alkyl; or phosphate esters according to formulae (IIA) and (IIB)



wherein R_2 is hydrogen or unsubstituted or alkyl-substituted C_2 - C_6 alkyl, and aromatic rings A and B independently of one another can have one or more alkyl substitutions;



wherein aromatic rings A, B and C independently of one another can have one or more alkyl substitutions, or formula (III)

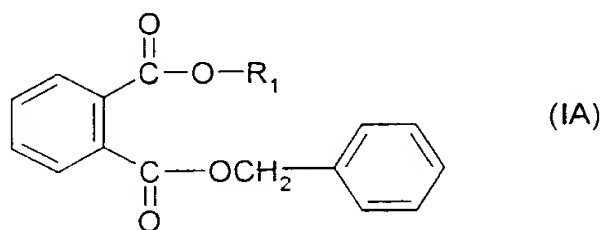


wherein R_3 , R_4 , R_5 , independently from one another, are unsubstituted or alkyl substituted C_1 - C_5 alkyl and R_6 , R_7 and R_8 are independently of one another are unsubstituted or alkyl-substituted C_1 - C_5 alkylene. More preferably, component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.

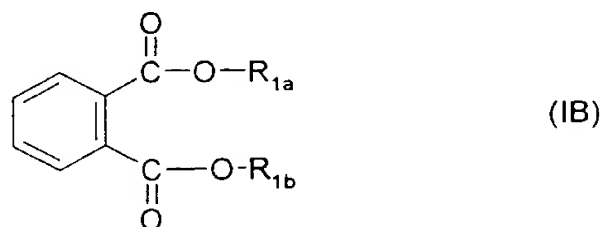
The present invention, in a further embodiment, is drawn to a cast polyurethane obtainable by a process comprising reacting (a) an isocyanate component or an isocyanate functional prepolymer having at least two isocyanate groups per molecule that contains or has been reacted with polytetramethylene glycol, (b) an aromatic amine curative, and (c) a phosphate ester or phthalate ester having a vapor pressure of less than 100 mPa at 25°C. Component (a) can be a prepolymer blend resulting from a reaction mixture of an organic diisocyanate

and polytetramethylene glycol. The aromatic amine curative used to obtain cast polyurethane is selected from the group consisting of diethyl toluene diamine, tertiary butyl toluene diamine, dimethylthiotoluene diamine, and 1,2-bis(2-aminophenylthio)ethane. The reactants for obtaining the desired cast polyurethane can further include a polyether- and/or polyester polyol having a number average molecular weight of at least 250.

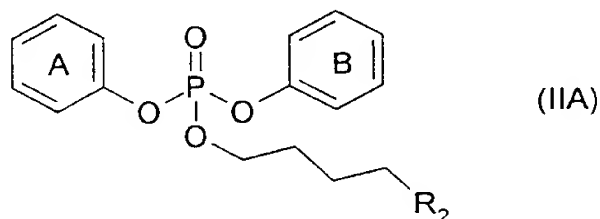
The phosphate ester or phthalate ester used for this process can preferably be represented by formulae (IA), (IB), (IIA), (IIB) or (III):



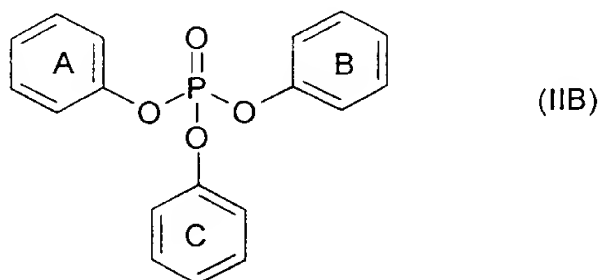
wherein R_1 is unsubstituted or alkyl-substituted C_3 - C_{12} alkyl,



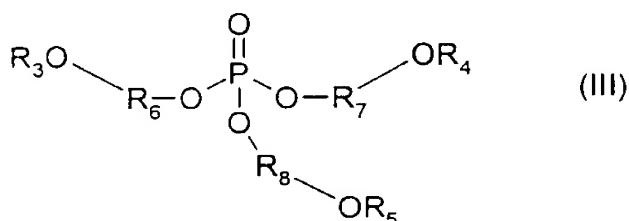
wherein R_{1a} and R_{1b} , independently of one another are unsubstituted or alkyl-substituted C_5 - C_{12} alkyl, or phosphate esters according to formulae (IIA) and (IIB)



wherein R_2 is hydrogen or unsubstituted or alkyl-substituted C_2 - C_6 alkyl, and aromatic rings A and B independently of one another can have one or more alkyl substitutions;



wherein aromatic rings A, B and C independently of one another can have one or more alkyl substitutions, or formula (III)



wherein R_3 , R_4 , R_5 , independently from one another, are unsubstituted or alkyl substituted C_1 - C_5 alkyl and R_6 , R_7 and R_8 are independently of one another are unsubstituted or alkyl-substituted C_1 - C_5 alkylene. More preferably, component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.

The present invention is drawn to a still further embodiment of a process for curing a poly urethane/urea-forming composition comprising contacting said poly urethane/urea-forming composition at a temperature between 15 and 35°C with (a) an aromatic amine curative having at least two primary amine groups, and (b) a plasticizer having a vapor pressure of less than 100 mPa at 25°C with said poly urethane/urea-forming composition.

DETAILED DESCRIPTION OF THE INVENTION

The isocyanate used in this invention is an isocyanate having an average functionality of two or more isocyanate groups per molecule. Examples of suitable diisocyanates are 2,4-toluene diisocyanate, 4,4-diphenylmethane diisocyanate, mixtures of diphenylmethane diisocyanate, paraphenyldiisocyanate, isophoronediiisocyanate, 4,4'-methylene-bis(cyclohexylisocyanate), naphthalene diisocyanate and hexamethylene diisocyanate and chain extended prepolymer blends. An alkylene diamine or diol can be reacted with an excess of the isocyanate component to produce such a chain extended prepolymer blends.

In a preferred embodiment, a low-free toluene diisocyanate prepolymer is made by reacting toluene diisocyanate with high molecular weight aliphatic polyester or polyether polyols to produce a prepolymer having a toluene diisocyanate content below 0.4% by weight, optionally by removal of excess toluene diisocyanate. Optionally, a mixture of a low molecular weight polyol (number average molecular weight less than 250) and a high molecular weight polyol (number average molecular weight of at least 250) can also be reacted with the toluene diisocyanate.

Representative toluene diisocyanates include the two main isomers, 2,4- and 2,6-diisocyanate and optionally, a small amount of the ortho isomers, the 2,3- and 3,4-isomers. Commercially, toluene diisocyanate is found as a 65:35, 80:20 or 99:1 isomer mix of the 2,4- and 2,6-isomer by weight and optionally from 0-5% by weight of the ortho isomers. An isomer mix is preferred within a range of from about 65-100% of the 2,4-isomer and the balance (0-35%) being essentially the 2,6-isomer. The most preferred range of the 2,6-isomer is 20-35%.

The 2,4-toluene diisocyanate dimer can be added to the selected organic diisocyanate(s) in an amount ranging up to the dimer's solubility limit at about 80°C to form an isocyanate blend. Preferably the dimer is present at up to about 6.0% by weight of the isocyanate blend, that is, the mixture of the toluene diisocyanate dimer and the selected organic diisocyanate(s). More preferably up to about 4.0% by weight of dimer may be present in the isocyanate blend.

High molecular weight polyols, particularly polyether polyols or polyester polyols having a number average molecular weight of at least 250, can be used to prepare the prepolymer of the instant invention. Polyols having a number average molecular weight of about 650 to 3000 are preferred, with polyols having number average molecular weights of 1000 being the most preferred. The number average molecular weight of the high molecular weight polyol can be as high as 10,000 or as low as 250. Preferred polyether polyols are polyalkyleneether polyols represented by the general formula $\text{HO}(\text{RO})_n\text{H}$, wherein R is an alkylene radical and n is an integer large enough that the polyether polyol has a number average molecular weight of at least 250. These polyalkyleneether polyols are well-known components of polyurethane products and can be prepared by the polymerization of cyclic

ethers such as alkylene oxides and glycols, dihydroxyethers, and the like by known methods. A particularly preferred high molecular weight polyol is polytetramethylene glycol.

Polyester polyols are prepared by reaction of dibasic acids (usually adipic acid but other components such as sebacic or phthalic acid may be present) with diols such as ethylene glycol, 1,2-propylene glycol, 1,4-butylen glycol and diethylene glycol, etc., where linear polymer segments are required, or include units of higher functionality such as glycerol, trimethylol propane, pentaerythritol, sorbitol, etc., if chain branching or ultimate cross-linking is sought. Some polyester polyols also employ caprolactone and dimerized unsaturated fatty acids in their manufacture. Another type of polyester which is of interest is that obtained by the addition polymerization of ϵ -caprolactone in the presence of an initiator. Other polyols that can be used are those that have at least two hydroxyl groups and whose basic backbone is obtained by polymerization or copolymerization of such monomers as butadiene and isoprene monomers.

The initial polyol portion for making a prepolymer blend of the instant invention can be combination of high molecular weight polyol, as previously described, and a low molecular weight polyol. An aliphatic glycol is the preferred low molecular weight polyol. Suitable aliphatic polyols are ethylene glycol, diethylene glycol, dipropylene glycol, neopentyl glycol, 1,3-butanediol, 1,4-butanediol, and the like. The most preferred low molecular weight polyol is 1,4-butanediol. In general, the weight of the low molecular weight polyol should be no more than 20% of the combination of high molecular weight polyol and low molecular weight polyol. The preferred range is 0 to 15% of the combination; more preferred is 0-8%.

The prepolymers are preferably prepared by loading toluene diisocyanate, then adding the polyol or initial polyol blend, maintaining the temperature at from room temperature to temperatures as high as 150°C for sufficient time to react all of the available hydroxyl groups, then removing unreacted toluene diisocyanate by vacuum distillation or other physical means. Preferred reaction temperatures are 50°C to 100°C; more preferred temperatures are 50°C to 85°C. The product is poured into containers under a nitrogen flush and stored at room temperature. A particularly preferred prepolymer is commercially available from Uniroyal Corporation under the tradename Adiprene[®] LF 750D.

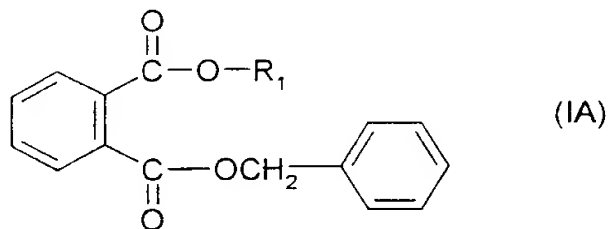
The stoichiometric ratio of isocyanato groups to hydroxyl groups in the reactants should preferably be from 2/1 to 30/1 although somewhat lower and higher ratios are permissible. When the ratio is much lower, the molecular weight of the isocyanato terminated polyurethane becomes so large (due to formation of oligomers with more than one polyol moiety) that the viscosity of the mass makes mixing of chain extenders into the prepolymer relatively more difficult. At the other extreme, an excess approaching the 30/1 ratio will result in high levels of free diisocyanate in the mixture (with higher removal costs). Therefore, the preferred range is 2.5/1 to 10/1.

The curative used with the prepolymer described above is an organic aromatic polyamine having two or more amine groups. The organic aromatic polyamine can be combined with polyether- and/or polyester-polyols described above to modify the final product or cure characteristics. Of course, known catalysts can be used in conjunction with the curative if necessary.

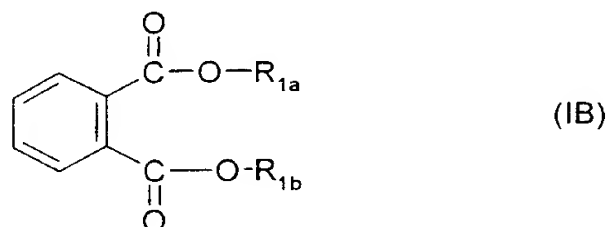
Examples of aromatic polyamine materials are: diethyl toluene diamine (DETDA), tertiary butyl toluene diamine (TBTDA), dimethylthiotoluene diamine (Ethacure™ 300) from Albermarle Corporation, trimethylene glycol di-p-aminobenzoate (Vibracure™ A157 from Uniroyal Chemical Company or Versalink™ 740 from AirProducts and Chemicals Inc.), and 1,2-bis(2-aminophenylthio)ethane (Cyanacure from American Cyanamid Company). The most preferred aromatic polyamine is dimethylthiotoluene diamine.

The castable composition combines the isocyanate component and/or prepolymer blend and curative described above with a plasticizing agent having a vapor pressure at 25°C of less than 100 mPa and/or an evaporation rate of <40% after 24 hours at 87°C according to ASTM 1203-67. The preferred plasticizing agents are phosphate or phthalate esters having a vapor pressure at 25°C of less than 100 mPa.

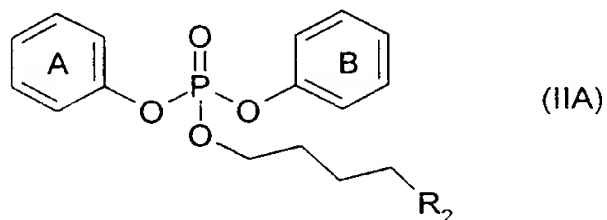
Particularly preferred plasticizing agents are alkyl benzyl phthalates monomers according to formulae (IA) and (IB)



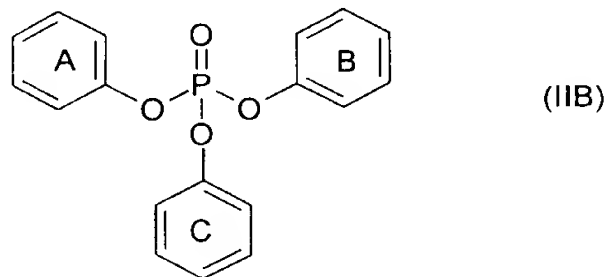
wherein R_1 is unsubstituted or alkyl-substituted C_3 - C_{12} alkyl,



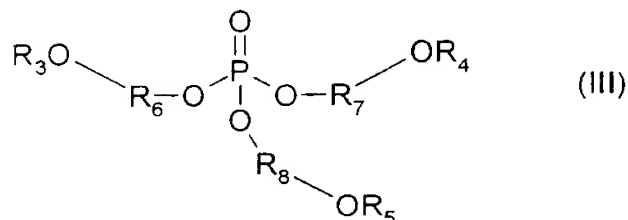
wherein R_{1a} and R_{1b} , independently of one another are unsubstituted or alkyl-substituted C_5 - C_{12} alkyl, preferably C_9 - C_{12} alkyl;
or phosphate esters according to formulae (IIA) and (IIB)



wherein R_2 is hydrogen or unsubstituted or alkyl-substituted C_2 - C_6 alkyl, and aromatic rings A and B independently of one another can have one or more alkyl substitutions;



wherein aromatic rings A, B and C independently of one another can have one or more alkyl substitutions,
or formula (III)



wherein R_3 , R_4 , R_5 , independently from one another, are unsubstituted or alkyl substituted C_1 - C_5 alkyl and R_6 , R_7 and R_8 are independently of one another are unsubstituted or alkyl-substituted C_1 - C_5 alkylene.

Representative compounds falling with formula (IA) are propyl benzyl phthalate, butyl benzyl phthalate (Santicizer 160, Solutia), pentyl benzyl phthalate, hexyl benzyl phthalate, heptyl benzyl phthalate (Santicizer 261, Solutia), octyl benzyl phthalate, nonyl benzyl phthalate, decyl benzyl phthalate and C_1 - C_3 alkyl-substituted compounds thereof. Another commercially available alkyl benzyl phthalate is Santicizer 278, Solutia). Representative compounds falling with formula (IB) are dipentyl phthalate, dihexyl phthalate, diheptyl phthalate, dioctyl phthalate, dinonyl phthalate, didecyl phthalate and C_1 - C_3 alkyl-substituted compounds thereof. Another commercially available alkyl benzyl phthalate is Santicizer 278, Solutia.

Representative compounds falling with formula (IIA) are pentyl diphenyl phosphate, hexyl diphenyl phosphate, heptyl diphenyl phosphate, octyl diphenyl phosphate, nonyl diphenyl phosphate and C_1 - C_3 alkyl substituted compounds thereof, such as isodecyl diphenyl phosphate (Santicizer 148) and 2-ethylhexyl diphenyl phosphate (Santicizer 141, Solutia) and Santicizer 2148 (Solutia). Representative compounds falling with formula (IIB) are triphenyl phosphate and tricresyl phosphate.

Representative monomers falling with formula (III) are tris(methoxymethyl)phosphate, tris(ethoxymethyl)phosphate, tris(propoxymethyl)phosphate, tris(butoxymethyl)phosphate, tris(pentoxymethyl)phosphate; tris(2-methoxyethyl)phosphate, tris(2-ethoxyethyl)phosphate, tris(2-propoxyethyl)phosphate, tris(2-butoxyethyl)phosphate, tris(2-pentoxyethyl)phosphate; tris(methoxypropyl)phosphate, tris(ethoxypropyl)phosphate, tris(propoxypropyl)phosphate, tris(butoxypropyl)phosphate, tris(pentoxypropyl)phosphate; tris(methoxybutyl)phosphate, tris(ethoxybutyl)phosphate, tris(propoxybutyl)phosphate, tris(butoxybutyl)phosphate, tris(pentoxybutyl)phosphate; tris(methoxypentyl)phosphate, tris(ethoxypentyl)phosphate,

tris(propoxypentyl)phosphate, tris(butoxypentyl)phosphate and tris(pentoxypentyl)phosphate. Isodecyl diphenyl phosphate is the most preferred.

The casting composition of the present invention is a mixture of the isocyanate component and/or isocyanate functional prepolymer blend, an aromatic amine curative, selected plasticizer(s) and optionally additional polyether- and/or polyester-polyol, and/or diisocyanate dimer. The mixture preferably contains about 40-80% by weight of an isocyanate functional prepolymer with an isocyanate content between 4 and 15% formed by the reaction of toluene diisocyanate with at least one polyol; 7-20% by weight of an aromatic polyamine; 6-30% by weight of a phosphate or phthalate ester plasticizer having a vapor pressure at 25°C of less than 100 mPa, and optionally, 0-20% by weight of uretdione diisocyanate (poly-HDI). In a more preferred embodiments, the isocyanate functional prepolymer blend has a free toluene diisocyanate content below 0.4%, most preferably below 0.1%.

A wide variety of fillers, dyes, and pigments can be used in the formulations described above. Examples of suitable fillers are calcium carbonate, clays, talcs, zinc oxide, titanium dioxide, and silica. The amount of filler usually is in the range of 0 to 800 parts per hundred by weight, depending on the application for which the formulation is intended.

Stabilizers known in the art can also be incorporated into the composition. The stabilizers may be for protection during the life of the finished product against, for example, oxygen, ozone, and ultra-violet radiation. Stabilizers can also be incorporated to protect against thermooxidative degradation during processing. Antioxidants and UV inhibitors that would otherwise interfere with the urethane curing process should be avoided. Preferred antioxidants are sterically hindered phenolic compounds. Stabilizers such as organic phosphites are also useful. Preferred UV inhibitors are benzotriazole compounds.

For curing these prepolymers, the number of $-NH_2$ groups in the aromatic diamine component should be approximately equal to the number of $-NCO$ groups in the isocyanate component and/or prepolymer blend. A small variation is permissible but in general from about 80 to 110% of the stoichiometric equivalent should be used, preferably about 85 to 100%.

The castable compositions described herein can be prepared by mixing the selected polyol(s) chain extenders with the isocyanate component and/or isocyanate functional preopolymer. The resulting chain extended product can then be used immediately or stored under a nitrogen blanket until such time that a casting is desired. The selected aromatic amine curative can be separately combined with the plasticizer and stored. Once a casting is desired, the chain extended product is combined with the aromatic amine curative and plasticizer and poured into a mould for curing and post-curing, if necessary.

Applications for cast elastomers include, potting and encapsulants, pipe seals, athletic surfaces, binders, drop hammer tools, prototype parts, foundry core boxes, pattern plates, bumping tools, working models for the ceramic industry and other moulded articles resulting from the formulations described herein. The present invention, therefore, further relates to moulded articles resulting from the formulations described herein. Preferably, the moulded article is free of any fiber reinforcing materials, such as carbon fibers, and yet exhibits a Shore D hardness in excess of about 45, more preferably in excess of about 50.

The following examples are illustrative of the present invention and are therefore not intended as a limitation on the scope thereof.

Example 1

The following components are combined in a closed vessel at ambient pressure and temperature. The components are intimately mixed for a sufficient time to produce a homogenous mixture, at which time the physical properties are determined.

Components

ADIPRENE LF750D	76.86g
Isodecyl diphenyl phosphate	23.02g
BYK A530	0.12g (degassing aid)
Dimethylthiotoluene diamine	17.00g

At 25°C viscosity of mixture is 3500 - 4000 mPas

Properties after curing at 25°C for 7days:

Shore D hardness (ISO 868) 50 - 53

Tensile strength (ISO527) 20 - 25 MPa
Elongation at break (ISO527) 150 - 200 %

Example 2

The components identified below are combined analogously to the methods described in example 1 to produce a homogenous mixture.

ADIPRENE LF750D 53.80g
DESMODUR N3400 23.06g
Isodecyl diphenyl phosphate 23.06g
BYK A530 0.08g (a degassing aid)
Dimethylthiotoluene diamine 24g

At 25°C viscosity of mixture is 1000 mPas

Properties after curing at 25°C for 7 days:

Shore D hardness (ISO 868) 63 - 66
Tensile strength (ISO527) 25 - 30 MPa
Elongation at break (ISO527) 150 - 200 %

Example 3

Several plasticizers identified below were used in a mixture of 76.86 grams Adiprene LF750D, 0.1 grams BYK A530 and 17 grams dimethylthiotoluene diamine. The mixtures are then introduced into a mould and cast into either a 400x75x100 mm bar or a 100 mm diameter circle having a 5 to 10 mm thickness. The mixtures are allowed to cure at ambient conditions for 16 hours. The resulting cured bars are demoulded and left on a flat surface. Distortion is shown when the ends of the cured bars curl upwards within three days of demoulding. The results of various plasticizers are shown below:

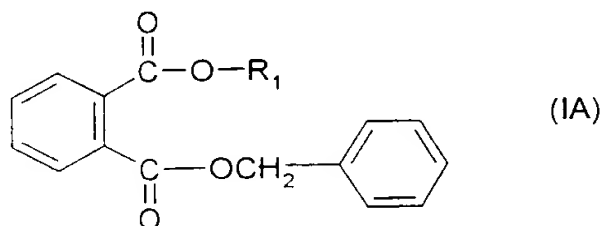
Plasticizer	Amount (g)	Evaporation rate	Vapor pressure at 25°C (mm Hg)	Vapor pressure at 25°C (mPa)	Distortion of cured specimens
gamma-butyrolactone	15.37		0.3	40000	Yes
Butyl glycol acetate	15.37		0.3	40000	Yes
Dibasic ester	12.3		0.08	11000	Yes
Propylene carbonate	15.37		0.08	11000	Yes
Dibutyl phthalate	23.06	44	0.0063	840	Slight
Ethylhexyl diphenyl phosphate	23.06	7.4	6×10^{-5}	8	No
Butyl benzyl phthalate	30.74	7.7	3×10^{-7}	4×10^{-2}	No
Isodecyl diphenyl phosphate	23.06	2.8	3×10^{-8}	4×10^{-3}	No
tributoxy ethyl phosphate	23.06	6.2	$10^{-4} - 10^{-6}$	0.13 - 13	No

Preferred embodiments of the present invention relating to novel poly urethane/urea-forming compositions and methods for using the same have been described above. Those skilled in the art having the benefit of the teachings presented in the foregoing will recognize modifications and other embodiments. Therefore, it is understood that the

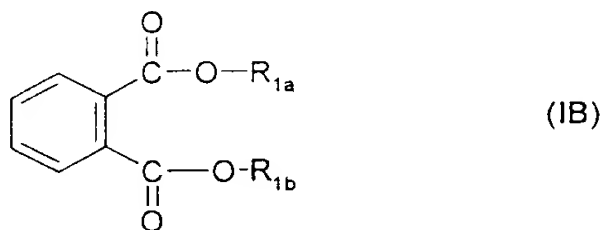
invention is not limited to the specific embodiments disclosed herein, and that modifications and other embodiments are intended to be within the scope of the appended claims.

Claims:

1. A poly urethane/urea-forming casting composition that can be cast and cured at temperatures between 15 and 35°C comprising a reaction mixture of (a) an isocyanate component or an isocyanate functional prepolymer having at least two isocyanate groups per molecule that contains or has been reacted with polytetramethylene glycol; (b) an aromatic amine curative; and (c) a phosphate ester or phthalate ester having a vapor pressure of less than 100 mPa at 25°C.
2. A casting composition according to claim 1 wherein component (a) is a low free toluene diisocyanate prepolymer blend having a free toluene diisocyanate content below 0.4%.
3. A casting composition according to claim 2 wherein the reaction mixture comprises a prepolymer blend that is a reaction mixture of an organic diisocyanate and polytetramethylene glycol.
4. A casting composition according to claim 1 wherein the aromatic amine curative is selected from the group consisting of diethyl toluene diamine, tertiary butyl toluene diamine, dimethylthiotoluene diamine, , and 1,2-bis(2-aminophenylthio)ethane.
5. A casting composition according to claim 4 wherein the aromatic amine curative is dimethylthiotoluene diamine.
6. A casting composition according to claim 5 further comprising a polyether- and/or polyester polyol having a number average molecular weight of at least 250.
7. A casting composition according to claim 1 wherein the phosphate ester or phthalate ester is represented by formulae (IA), (IB), (IIA), (IIB) or (III):

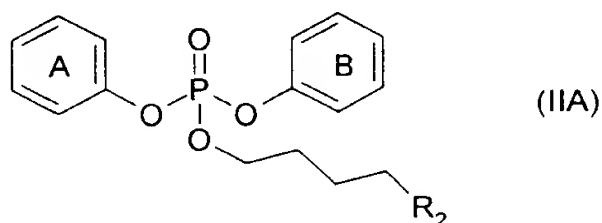


wherein R₁ is unsubstituted or alkyl-substituted C₃-C₁₂alkyl,

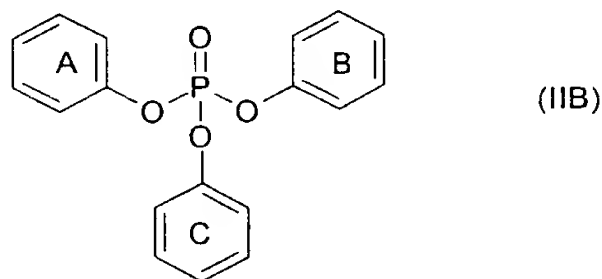


wherein R_{1a} and R_{1b} , independently of one another are unsubstituted or alkyl-substituted C_5 - C_{12} alkyl;

or phosphate esters according to formulae (IIA) and (IIB)

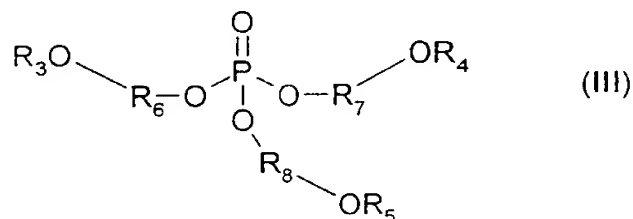


wherein R_2 is hydrogen or unsubstituted or alkyl-substituted C_2 - C_6 alkyl, and aromatic rings A and B independently of one another can have one or more alkyl substitutions;



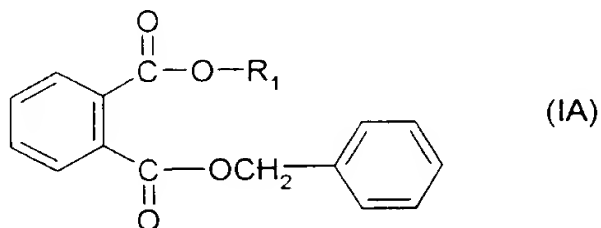
wherein aromatic rings A, B and C independently of one another can have one or more alkyl substitutions,

or formula (III)

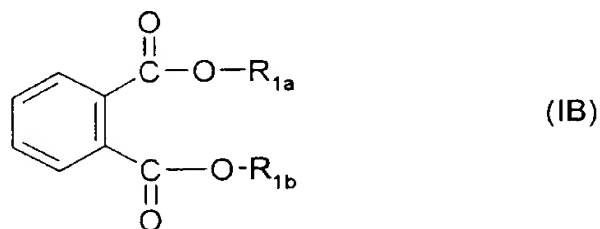


wherein R_3 , R_4 , R_5 , independently from one another, are unsubstituted or alkyl substituted C_1 - C_5 alkyl and R_6 , R_7 and R_8 are independently of one another are unsubstituted or alkyl-substituted C_1 - C_5 alkylene.

8. A casting composition according to claim 1 wherein component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.
9. A casting composition according to claim 5 wherein component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.
10. A cast polyurethane obtainable by a process comprising reacting (a) an isocyanate component or an isocyanate functional prepolymer having at least two isocyanate groups per molecule that contains or has been reacted with polytetramethylene glycol; (b) an aromatic amine curative; and (c) a phosphate ester or phthalate ester having a vapor pressure of less than 100 mPa at 25°C.
11. A polyurethane casting according to claim 10 wherein component (a) is a low free toluene diisocyanate prepolymer blend having a free toluene diisocyanate content below 0.4%.
12. A polyurethane casting according to claim 11 wherein component (a) is a prepolymer blend resulting from a reaction mixture of an organic diisocyanate and polytetramethylene glycol.
13. A polyurethane casting according to claim 10 wherein the aromatic amine curative is selected from the group consisting of diethyl toluene diamine, tertiary butyl toluene diamine, dimethylthiotoluene diamine, and 1,2-bis(2-aminophenylthio)ethane.
14. A polyurethane casting according to claim 13 wherein the aromatic amine curative is dimethylthiotoluene diamine.
15. A polyurethane casting according to claim 14 wherein the process further comprising combining a polyether- and/or polyester polyol having a number average molecular weight of at least 250 with components (a), (b) and (c).
16. A polyurethane casting according to claim 10 wherein the phosphate ester or phthalate ester is represented by formulae (IA), (IB), (IIA), (IIB) or (III):

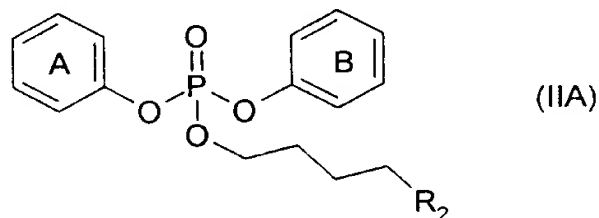


wherein R_1 is unsubstituted or alkyl-substituted C_3 - C_{12} alkyl,

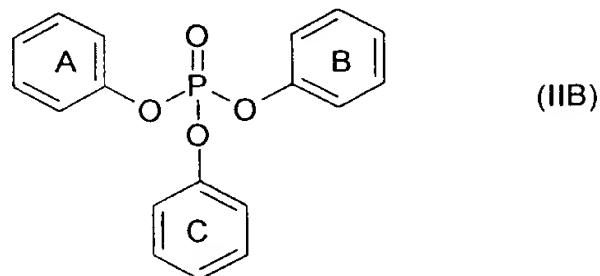


wherein R_{1a} and R_{1b} , independently of one another are unsubstituted or alkyl-substituted C_5 - C_{12} alkyl,

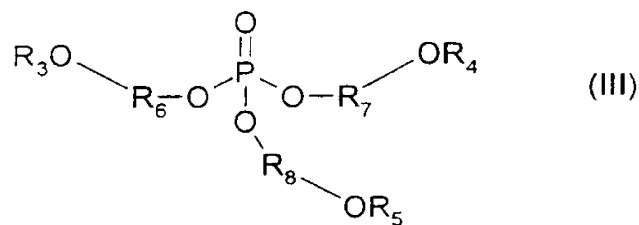
or phosphate esters according to formulae (IIA) and (IIB)



wherein R_2 is hydrogen or unsubstituted or alkyl-substituted C_2 - C_6 alkyl, and aromatic rings A and B independently of one another can have one or more alkyl substitutions;



wherein aromatic rings A, B and C independently of one another can have one or more alkyl substitutions,
or formula (III)



wherein R_3 , R_4 , R_5 , independently from one another, are unsubstituted or alkyl substituted C_1 - C_5 alkyl and R_6 , R_7 and R_8 are independently of one another are unsubstituted or alkyl-substituted C_1 - C_5 alkylene.

17. A polyurethane casting according to claim 10 wherein component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.

18. A polyurethane casting according to claim 14 wherein component (c) is tributoxyethyl phosphate or isodecyl diphenyl phosphate.

19. A process for curing a poly urethane/urea-forming composition according to claim 1 comprising contacting said poly urethane/urea-forming composition at a temperature between 15 and 35°C with (a) an aromatic amine curative having at least two primary amine groups; and (b) a plasticizer having a vapor pressure of less than 100 mPa at 25°C with said poly urethane/urea-forming composition.

INTERNATIONAL SEARCH REPORT

International Application No.

PCT/EP 99/10040

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 C08G18/48 C08G18/10 C08K5/00 C08K5/12 C08K5/51

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08G C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>DATABASE WPI Section Ch, Week 199408 Derwent Publications Ltd., London, GB; Class A25, AN 1994-062111 XP002132421 & JP 06 016767 A (BANDO CHEM IND LTD), 25 January 1994 (1994-01-25) abstract</p>	1,3,4,7, 10,12, 13,16
X	<p>US 3 980 606 A (WERNER BYRON H) 14 September 1976 (1976-09-14) column 1, line 23 -column 2, line 9 examples III,IV</p>	1,3,7, 10,12,16
P,X	<p>FR 2 764 893 A (GANGA ROLAND ALEXANDRE) 24 December 1998 (1998-12-24) example 5</p>	1,3-5, 10,12-14

-/-

☒ Further documents are listed in the continuation of box C.☒ Patent family members are listed in annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"Z" document member of the same patent family

Date of the actual completion of the international search

9 March 2000

Date of mailing of the international search report

23/03/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentplan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Neugebauer, U

INTERNATIONAL SEARCH REPORT

International Application No.

PCT/EP 99/10040

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 376 674 A (MITSUI TOATSU CHEMICALS) 4 July 1990 (1990-07-04) page 3, line 20 - line 28 page 4, line 22 -page 5, line 27 example 1; table 1 —	1,3,4,7, 10,12, 13,16
A	US 5 688 892 A (ISHII AKIRA ET AL) 18 November 1997 (1997-11-18) cited in the application example 1 —	1,4,7,19

INTERNATIONAL SEARCH REPORT

information on patent family members

International Application No.

PCT/EP 99/10040

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
JP 6016767	A	25-01-1994	JP 2051847 C JP 7072223 B	10-05-1996 02-08-1995
US 3980606	A	14-09-1976	NONE	
FR 2764893	A	24-12-1998	AU 8024698 A WO 9858979 A	04-01-1999 30-12-1998
EP 0376674	A	04-07-1990	CA 2006725 A CN 1048225 A,B DE 68921866 D DE 68921866 T JP 2258877 A KR 9303016 B US 5059671 A	28-06-1990 02-01-1991 27-04-1995 27-07-1995 19-10-1990 16-04-1993 22-10-1991
US 5688892	A	18-11-1997	JP 8143816 A CN 1127512 A WO 9529198 A	04-06-1996 24-07-1996 02-11-1995